

Work Order ID 137161

137161

Page 1

Thursday, September 24, 2015 2:11:08 PM

Item ID: D4476-042 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Small Rib Assembly, RH
 Start Date: 9/23/15 Start Qty: 1.00 ****1**** Cust Item ID:
 Required Date: 9/23/15 Req'd Qty: 1.00 ****4**** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: SEP 23 2015 Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4476	REV B								

100 0.00
100
 Bandsaw Memo 0.00
 Jeaspa Bandsaw CUT BLANK 4.250" LONG

110 0.00
110
 Purchasing Memo 0.00
 Purchasing ISSUE P/O: 30108
 TO ARCHUR PRECISION(GLOBUS)
 C OF C IS REQUIRED

120 0.00
120
 QC Memo 0.00
 Quality Control

DAS
 38
 9-89
 NOV 05 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER : _____			
Misidentified	☐	Past Due	☐				

Work Order ID 137161

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Item ID: D4476-042 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Small Rib Assembly, RH
 Start Date: 9/23/15 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 9/23/15 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				5	FF	NOV 09 2015	
140 *140* QC Quality Control	QC7-Inspect Chemical Conversion Coat Memo	0.00 0.00				5		DAS 38 9-89 NOV 09 2015	
141 *141* SprayPaint Spray Painting	Spray Painting per QSI005 4.2 Memo PRIME TEMPO GREY 132900	0.00 0.00				5		DAS 41 9-89 15-11-20	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		OTHER : _____					

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

Work Order ID 137161***137161***

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Thursday, September 24, 2015 2:11:08 PM

Item ID: D4476-042 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Small Rib Assembly, RH
Start Date: 9/23/15 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 9/23/15 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200	Identify as per dwg & Stock Location: <u>St101</u>	0.00				<u>5</u>	<u>MLJ</u>	<u>NOV 23 2015</u>	
200									
Packaging	Memo	0.00							
Packaging									
210	QC21- Final Inspection - Work Order Release	0.00							
210						<u>MLJ</u>	<u>15-11-24</u>		
QC	Memo	0.00							
Quality Control									

MLJ 15-11-23

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								

Picklist Print

Thursday, September 24, 2015 2:11:08 PM

Page 1

Work Order ID: 137161

137161

Parent Item: D4476-042

D4476-042

Parent Item Name: Small Rib Assembly, RH

Start Date: 9/23/15

Required Date: 9/23/15

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A NEW ISSUE 13-01-17 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D4476-2P		Purchased	No				Each	0.0000		1			
D4476-2P									**				
Small Rib, RH													
MS20426AD3-4		Purchased	No				Each	3,718.000		2			
MS20426AD3-4									**				
RIVET													

Location Loc Qty Loc Code

GA	3169	
m131697	3169	
ST313	549	
125578	7	
m125578	181	
m127432	361	

10

MS21059L08		Purchased	No				Each	266.0000		1			
MS21059L08									**				
Nut													

Location Loc Qty Loc Code

ST260a	200	
m131697	200	
ST303	66	
125654	62	
m131624	4	

5

DAS
36
9-89

DAS
36
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER :			
Misidentified	☐	Past Due	☐				

Picklist Print

Page 2

Thursday, September 24, 2015 2:11:08 PM

Work Order ID: 137161

137161

Parent Item: D4476-042

D4476-042

Parent Item Name: Small Rib Assembly, RH

Start Date: 9/23/15

Required Date: 9/23/15

Start Qty: 1.00

Required Qty: 1.00

M6061T6B0.750X03.00

Purchased

No

f

8.4146

0.372632

0

M6061T6B0 750X03 000

6061-T6 Bar .750 x 3.00

Location

Loc Qty

Loc Code

MAT002

8.4146

m128437

8.4146

1.906 J.C.L. 9/24/15

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

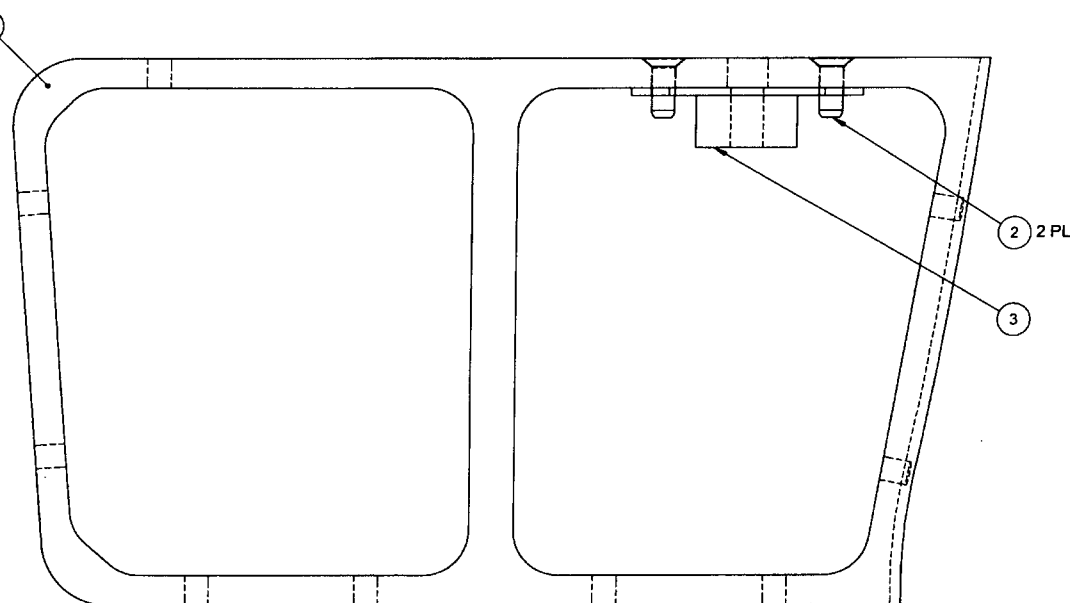
QA Closed: _____ Date: _____

Work Order update only ☐

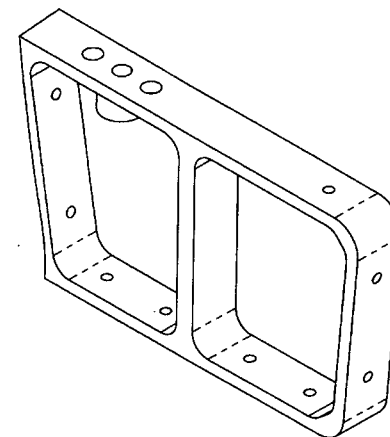
Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER : _____			
Misidentified	☐	Past Due	☐				

ITEM	QTY -041	P/N	DESCRIPTION
	X	D4476-041	SMALL RIB ASSY (LH)
1	1	D4476-1	SMALL RIB (LH)
2	2	MS20426AD3-4	RIVET, CSK
3	1	MS21059L08	NUTPLATE



D4476-041 SMALL RIB ASSY (LH)



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 137161 MJS

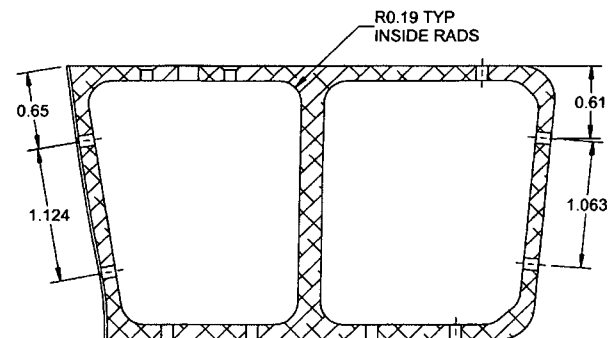
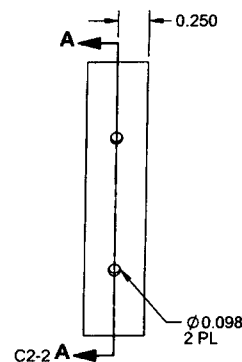
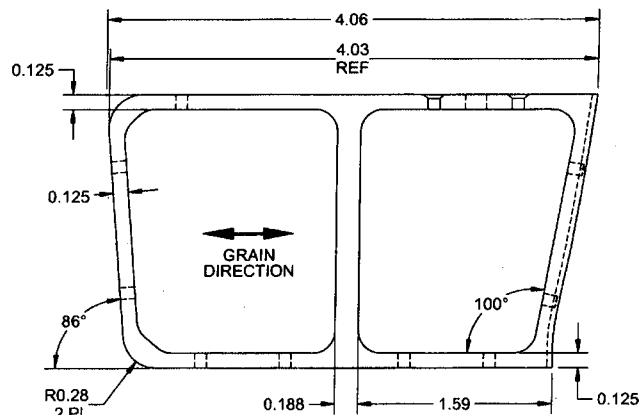
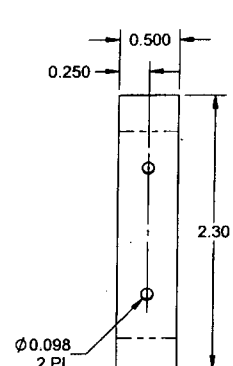
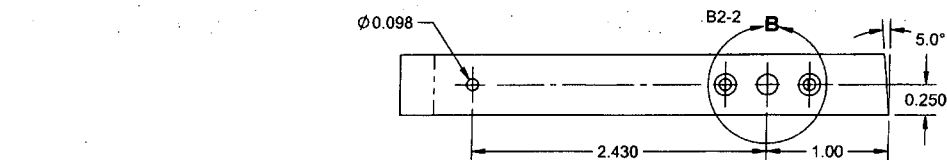
15-09-25

RELEASED
2012-09-18

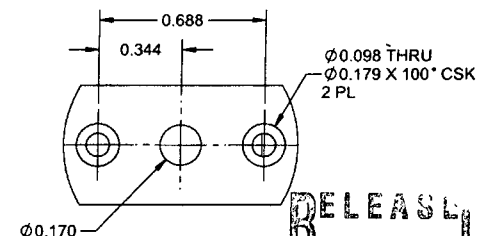
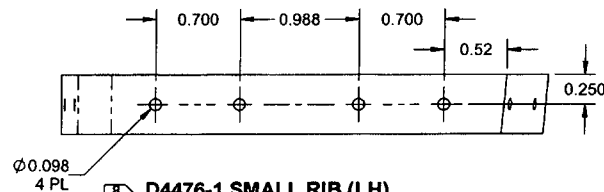
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.10 lbs

B	GENERAL REVISION SEE REV. A FOR DETAILS. ADDED -042 AND -2. ADDED PRIMER NOTE.	AJS	12.09.10
A	NEW ISSUE	AJS	11.11.22
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	A.P.	DRAWING NO.	REV. B
MFG. APPR.		D4476	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		SMALL RIB ASSY	NTS
DATE	12.09.10	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



SECTION A-A B4-2



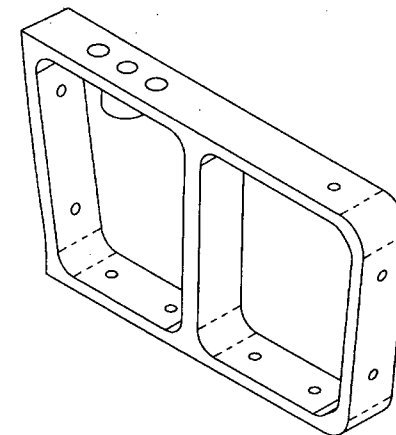
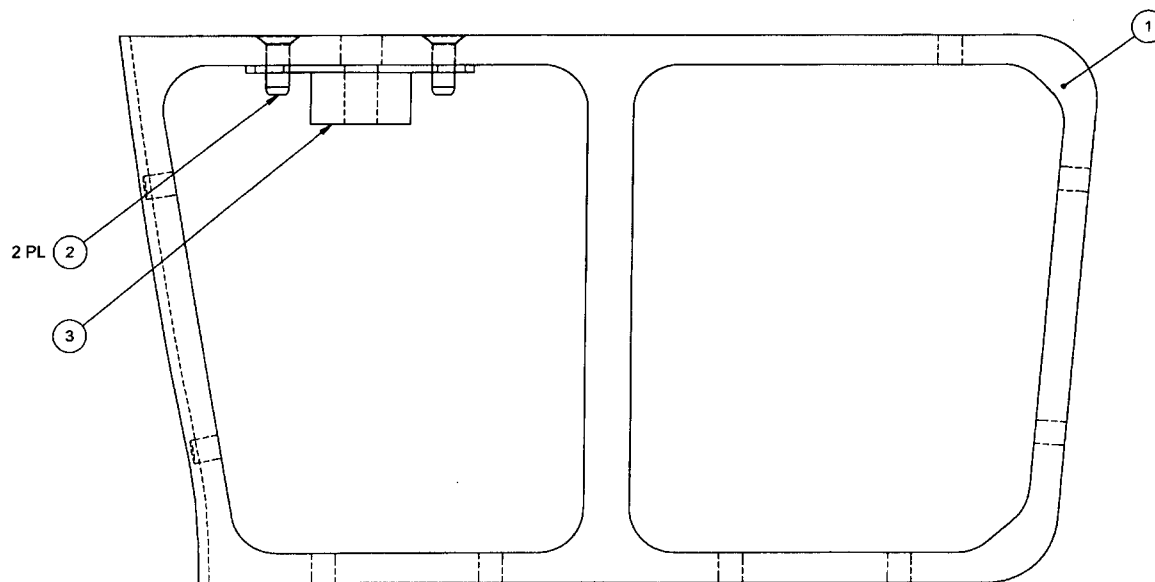
DETAIL B D5-2
SCALE 2X

- NOTES:
- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME TEMPO GREY (4.2.1.3.2) PER DART QSI 005 4.2
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.09 lbs
 - 8) ALL NON-DIMENSIONED FEATURES DEFINED PER CAD FILE "D4476-1-REVB.STP"
 - 9) RAW MATERIAL SURFACE FINISH SUFFICIENT FOR THIS PART
(NOT NECESSARY TO FACE MATERIAL)

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	AJS	DRAWING NO. D4476	REV. B SHEET 2 OF 4
MFG. APPR.		TITLE SMALL RIB ASSY	SCALE NTS
APPROVED		COPYRIGHT © 2012 BY DART AEROSPACE LTD	
DE APPR.		THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMERCE TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	12.09.10		

RELEASED
2012-09-18

ITEM	QTY -042	P/N	DESCRIPTION
	X	D4476-042	SMALL RIB ASSY (RH)
1	1	D4476-2	SMALL RIB (RH)
2	2	MS20426AD3-4	RIVET, CSK
3	1	MS21059L08	NUTPLATE



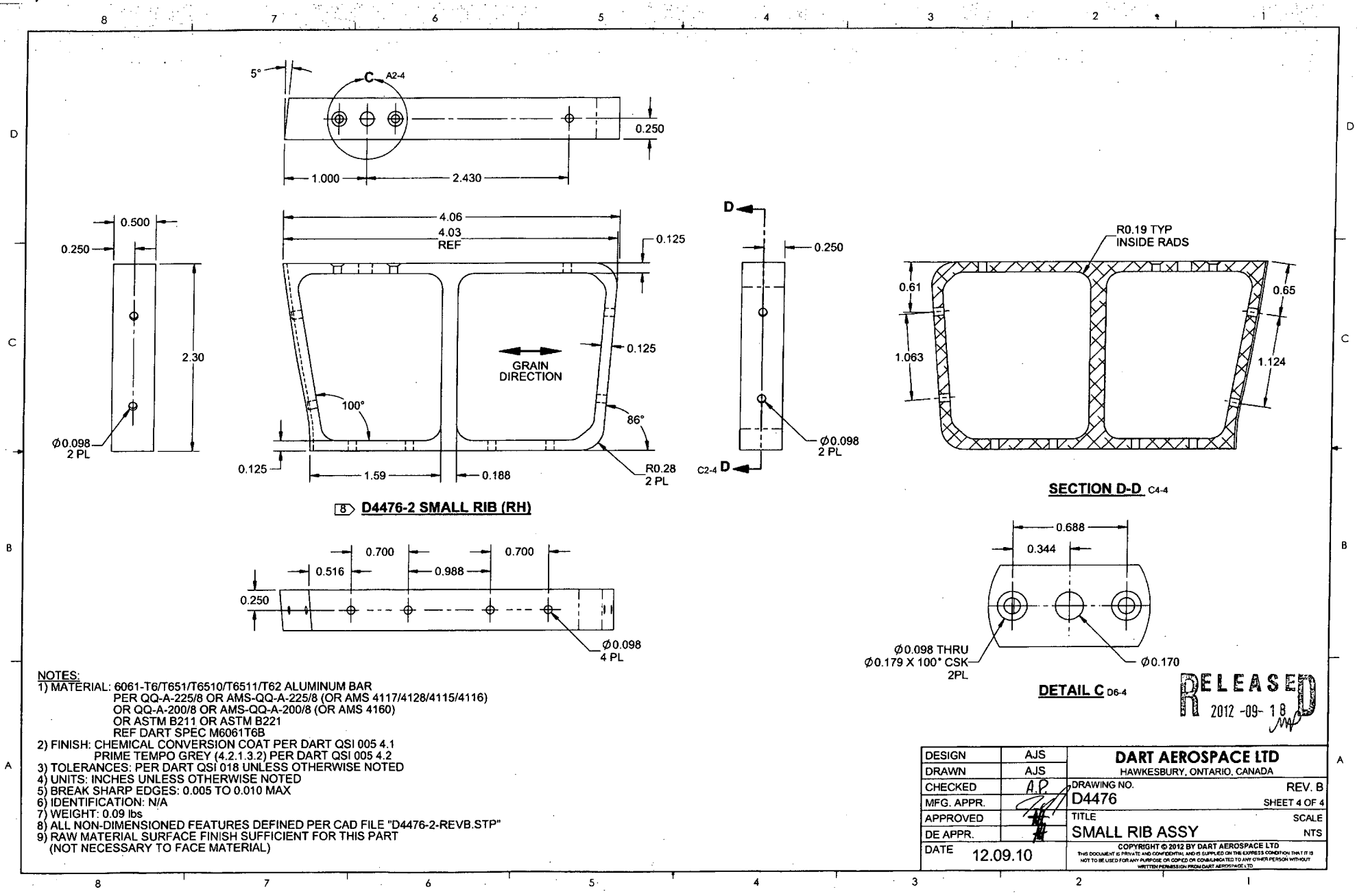
D4476-042 SMALL RIB ASSY (RH)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.10 lbs

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	AJS	DRAWING NO. D4476	REV. B
MFG. APPR.	<i>[Signature]</i>	TITLE	SHEET 3 OF 4
APPROVED	<i>[Signature]</i>	SMALL RIB ASSY	SCALE
DE APPR.	<i>[Signature]</i>		NTS
DATE	12.09.10	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

RELEASED
2012-09-18
MP



- NOTES:
- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME TEMPO GREY (4.2.1.3.2) PER DART QSI 005 4.2
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.09 lbs
 - 8) ALL NON-DIMENSIONED FEATURES DEFINED PER CAD FILE "D4476-2-REVB.STP"
 - 9) RAW MATERIAL SURFACE FINISH SUFFICIENT FOR THIS PART
(NOT NECESSARY TO FACE MATERIAL)

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>AP</i>	DRAWING NO.	REV. B
MFG. APPR.		D4476	SHEET 4 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SMALL RIB ASSY	NTS
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RELEASED
2012-09-18



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO30108**

Purchase Order Date 10/13/2015

PO Print Date 10/13/2015

Page Number 1 of 2

Order From :

VC-GLO001

Ship To : DART AEROSPACE LTD

ARCHER PRECISION INC.
2228 GLADWIN CRESENT
OTTAWA, ON K1B 4S6
CA

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone 613 899 2405

Ship To Contact

Ship To Phone

Ship Via: FedEx Overnight collect

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax # 10127-2607

Terms

Net 30

Currency

CAD

FOB

EXW - (Ex Works)

Line Nbr	Reference Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
	Line Comments		Promise Date				
	Delivery Comments						
1	D4476-2P	Small Rib, RH	10/30/2015		5.00	\$85.92	\$429.60
			Yes		Each		
			10/30/2015				
	AS PER DWG D4476 REV. B						
	B137161						
Line Total:							\$429.60
2	71401-45	PROCUREMENT QUALITY CLAUSES	10/30/2015		1.00	\$0.00	\$0.00
			No				
			10/30/2015				
	Procurement Quality Clauses						
	A005 RIGHT OF ENTRY						
	A007 FIRST ARTICLE INSPECTION (FAI) BY SELLER,						
	(DOCUMENTATION MAINTAINED BY SUPPLIER)						
	A016 PERSONNEL QUALIFICATION						
	A026 CERTIFICATION OF MATERIAL CONFORMANCE						
	A040 NOTIFICATION OF QUALITY ESCAPE						
	A042 DART NOTIFICATION BY SUPPLIER						
	A043 RETENTION OF QUALITY DOCUMENTS						

PO Instructions: Fedex Acc#151793240

Note:

10/13/2015



2228 Gladwin Crescent
Ottawa, Ontario
K1B 4S6

Phone # 613-899-2405

Packing Slip

Date	Invoice #
10/31/2015	1790

Ship To
Main Finished Goods Location Dart Aerospace 1270 Aberdeen Street Hawksbury, Ontario K6A 1K7

P.O. No.	Ship	Via	FOB	Project
30108	10/31/2015	delivered	Archer	

Qty	Item Code	Description
5 ✓	Sales	D4476-2P HST (ON) on sales SP15-11-01



2228 Gladwin Cres.
Ottawa, Ont.
K1B 4S6

Telephone (613) 899-2405
Fax (613) 226-1719

Certificate of Compliance

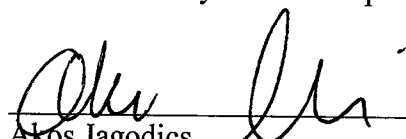
To:
Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury Ont.
K6A 1K7

2 November 2015

Po Number	Part Number	Quantities
30108	Line item 1 D4476-2P	5 ✓

SP15-11-01

It is hereby certified that all articles mentioned above are in conformance with the requirements, specification and drawings as listed on customer purchase order number, 30108 issued by Dart Aerospace Inc.


Akos Jagodics
Quality Inspector
Archer Precision Inc.
2228 Gladwin Cress.
Ottawa, Ontario
K1B 4S6



INSPECTION REPORT

Date : 10/27/15



Customer : * u_cus *

Part No.: * u_prtnu *

Plan Name D4472 REVb2

Rev.:

Customer PO.: * u_Cuspo *

BSN :

Incr. Smpl No.: 2

Name	ID	Actual	Nominal	pos Tol	neg Tol	Diff	<-- -->
☐ Hole 1 Diameter	D	1.24697	1.25000	0.01200	-0.00100	-0.00303	-0.00203
☐ True Position_Hole 1	Po2d	0.00654	0.00000	0.03000		0.00654	-
	X	12.46340	12.46085			0.00255	
	Y	-2.18953	-2.18749			-0.00204	
☐ Hole 2 Diameter	D	0.19852	0.19350	0.00500	-0.00100	0.00502	0.00002
☐ True Position_Hole 2a	Po2d	0.00586	0.00000	0.03000		0.00586	-
	X	10.77915	10.77700			0.00214	
	Y	-0.55449	-0.55249			-0.00200	
☐ True Position_Hole 2b	Po2d	0.00548	0.00000	0.03000		0.00548	-
	X	5.05576	5.05404			0.00172	
	Y	-0.57463	-0.57250			-0.00213	
☐ True Position_Hole 2c	Po2d	0.00624	0.00000	0.03000		0.00624	-
	X	11.30089	11.29891			0.00198	
	Y	-4.26840	-4.26599			-0.00241	
☐ True Position_Hole 2d	Po2d	0.00656	0.00000	0.03000		0.00656	-
	X	3.81224	3.80996			0.00228	
	Y	-3.30474	-3.30238			-0.00236	
☐ Diameter_Hole 3a	D	0.16900	0.16600	0.00500	-0.00100	0.00300	--
☐ True Position_Hole3a	Po2d	0.01789	0.00000	0.03000		0.01789	--
	Z	-0.24122	-0.25000			0.00878	
	X	1.25172	1.25000			0.00172	
☐ True Position_Hole 3b	Po2d	0.01043	0.00000	0.03000		0.01043	--
	Z	-0.24538	-0.25000			0.00462	
	X	7.00241	7.00000			0.00241	
☐ True Position_Hole 3c	Po2d	0.01502	0.00000	0.03000		0.01502	--
	Z	-0.24292	-0.25000			0.00708	
	X	14.00252	14.00000			0.00252	
☐ Hole4 Diameter	D	0.09880	0.09800	0.00400	-0.00110	0.00080	--
☐ True Position_Hole4	Po2d	0.00989	0.00000	0.03000		0.00989	--
	Z	-0.24817	-0.25000			0.00183	
	X	8.62932	8.62472			0.00460	
☐ Diameter_Hole 5	D	0.09892	0.09800	0.00400	-0.00100	0.00092	-
☐ True Position_Hole 5	Po2d	0.01107	0.00000	0.03000		0.01107	--
	Y	-1.50231	-1.49965			-0.00265	
	Z	-0.24514	-0.25000			0.00486	
☐ Diameter_Hole 6	D	0.19465	0.19350	0.00500	-0.00100	0.00115	--
☐ True Position_Hole 6	Po2d	0.00663	0.00000	0.03000		0.00663	-
	X	13.72179	13.71903			0.00276	
	Y	-1.75463	-1.75280			-0.00183	
☐ True Position_Hole6b	Po2d	0.00709	0.00000	0.03000		0.00709	-
	X	13.97399	13.97128			0.00271	
	Y	-3.97291	-3.97063			-0.00228	
☐ Diameter_Hole7a	D	0.13081	0.12850	0.00400	-0.00100	0.00231	--

BSN: 2

Name	ID	Actual	Nominal	pos Tol	neg Tol	Diff	<-- -->
■ True Position_Hole7a	Po2d	0.01077	0.00000	0.01000		0.01077	0.00077
	X	0.44136	0.43958			0.00178	
	Y	-0.43963	-0.43455			-0.00508	
■ True Position_Hole7b	Po2d	0.01094	0.00000	0.01000		0.01094	0.00094
	X	0.81633	0.81458			0.00175	
	Y	-0.50223	-0.49705			-0.00519	
■ True Position_Hole7c	Po2d	0.01052	0.00000	0.01000		0.01052	0.00052
	X	0.44157	0.43958			0.00198	
	Y	-0.93942	-0.93455			-0.00487	
■ True Position_Hole7d	Po2d	0.01101	0.00000	0.01000		0.01101	0.00101
	X	0.81639	0.81458			0.00181	
	Y	-1.12725	-1.12205			-0.00520	
■ True Position_Hole7e	Po2d	0.01113	0.00000	0.01000		0.01113	0.00113
	X	0.44137	0.43958			0.00178	
	Y	-1.43982	-1.43455			-0.00527	
■ True Position_Hole7f	Po2d	0.01140	0.00000	0.01000		0.01140	0.00140
	X	0.81629	0.81458			0.00170	
	Y	-1.75249	-1.74705			-0.00544	
■ Rib 1 Angle	A	65.49709	65.50000	0.50000	-0.50000	-0.00291	-
■ Rib 2 Angle	A	90.00020	90.00000	0.50000	-0.50000	0.00020	-
■ Rib3 Angle	A	97.99877	98.00000	0.50000	-0.50000	-0.00123	-
■ Pocket Depth	Z	-0.49980	-0.50000	0.00500	-0.00500	0.00020	-
■ Curve Form	CurvForm	0.00107	0.00000	0.01000	-0.01000	0.00107	-
■ Curve Form at .350	CurvForm	0.00717	0.00000	0.01000	-0.01000	0.00717	---